

- NOTES
1. DRILL HOLES FOR SCREWS PICKING UP EXISTING RIVET HOLES AT APPROXIMATELY THE DISTANCES SHOWN.
 2. INSTALL ALL RIVETS IN ACCORDANCE WITH AC43.13-1B, PAR 4-58, AND FIG. 4-6 USING THE FOLLOWING LEGEND:
 - ⊙ EXISTING RIVET (REF)
 - + MS20470AD3
 - * MS20470AD4
 - ⊗ MS20426AD3
 - ⊙ MS20426AD4
 3. PICK UP EXISTING RIVET HOLES IN DOOR THROUGHOUT ENTIRE PANEL.
 4. PLACARD INSTRUMENT PANEL WITH ITEM 8 AS SHOWN.

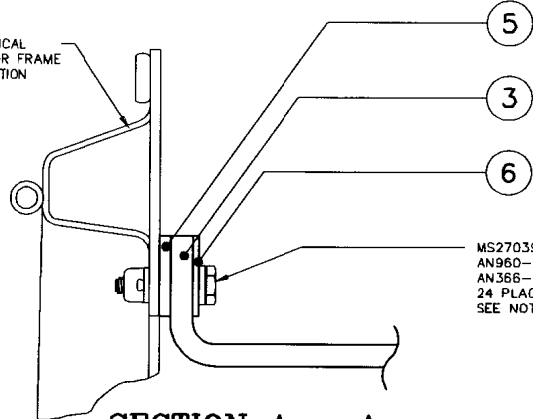
1 INSTALLATION - BUBBLE WINDOW

SCALE 1 : 3

NOTICE			
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
4	ADDED SHEET 3 / MODIFIED DOOR INNER SKIN / CHG'D DOOR LATCH	SV	2 APR 1998
5	LARGER INST. WINDOW / LARGER RIBS / INST. PANEL CHANGED	DW	15 AUG 2000

CAUTION
Vertical Sighting Bubble
Door fitted - Ensure top
latch secured for flight.

TYPICAL
DOOR FRAME
SECTION

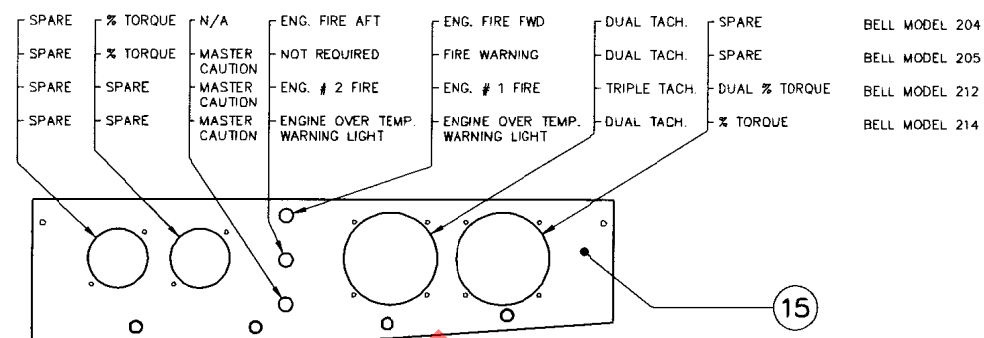


SECTION A - A

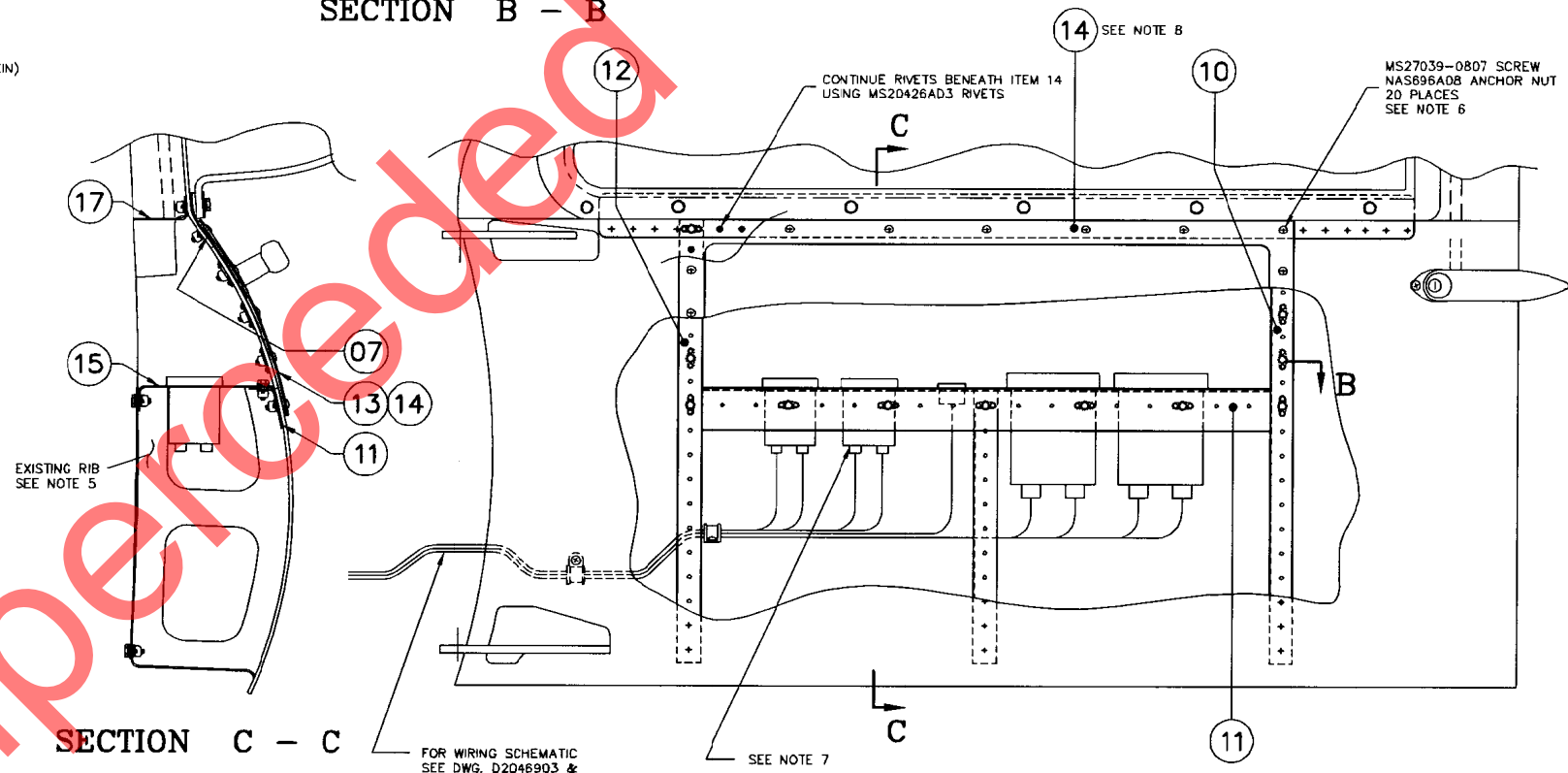
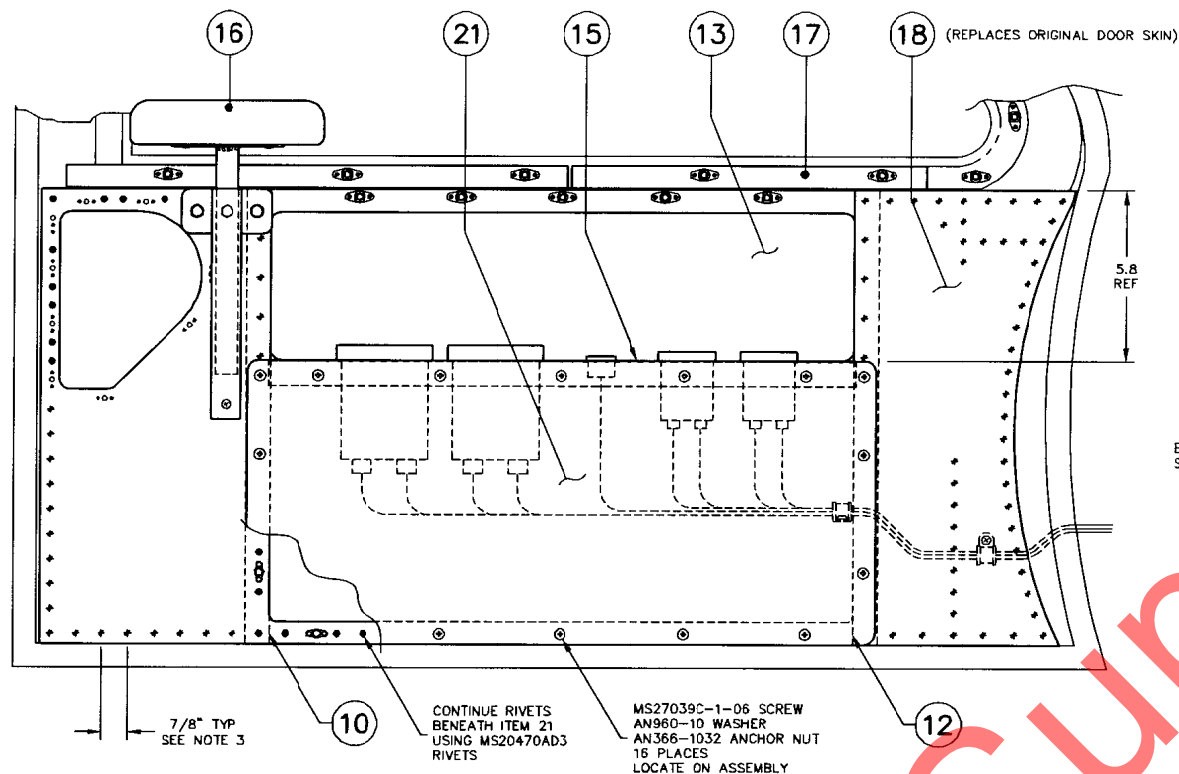
SCALE : FULL

QTY.	DASH NO.	DESCRIPTION	PART NO.
4	28	ARM GUIDE	EA20469-28
1	27	DOOR PLATE	EA20469-27
1	26	DOOR PLATE	EA20469-26
1	25	ARM	EA20469-25
1	24	ROD	EA20469-24
2	23	LINK	EA20469-23
2	22	LUG	EA20469-22
1	21	DOOR COVER PANEL	EA21469-21
	20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20
	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20
	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20
1	20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19
1	18	DOOR INNER SKIN	EA20469-18
1	17	ANGLE	EA20469-17
1	16	ARM REST ASSEMBLY	EA20469-16
1	15	INSTRUMENT PANEL	EA20469-15
1	14	WINDOW RETAINER	EA20469-14
1	13	INSTRUMENT WINDOW	EA20469-13
1	12	FORWARD RIB	EA20469-12
1	11	ANGLE	EA20469-11
1	10	REARWARD RIB	EA20469-10
1	9	ANGLE	EA20469-09
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08
1	7	ANGLE	EA20469-07
1	6	ALUMINUM STRIP	EA20469-06
1	5	RUBBER STRIP	EA20469-05
1	4	DOOR LATCH ASSEMBLY	EA20469-04
1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03
	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS	
	1	INSTALLATION - BUBBLE WINDOW	
2	1	DASH NO.	

BASIC CODE		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		DASH NO. FOR LENGTH		APPROVALS		DATE		AERO DESIGN LTD.	
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C-COUNTERSUNK						DRAWN: E. BURGOIN		26 AUG 91		CONSULTING ENGINEERS TRANSPORT CANADA APPROVALS, BAR 8908 1046 MCATAVISH ROAD N.E., CALGARY, AL. T2E 7G9	
BASIC CODES: BJ = MS20470AD BB = MS20426AD LZ = NAS1097AD CX = MS20470DD		* □ INSTALL NEW RIVET		+ ⊕ REMOVE/REPLACE RIVET		CHECKED:				EAGLE COPTERS LTD.	
		- EXISTING RIVET				STRESS:				823 MCTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9	
						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION	
						DECIMALS: X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES: ±1/2°		SCALE AS NOTED	
										DWG. SIZE A1	
										DWG. NO. D2046901	
										SHEET 1 OF 3	
										REV. 5	



SECTION B - B



SECTION C - C

② ASSEMBLY - DOOR MOUNTED INSTRUMENTS

2. INSTALL ALL RIVETS IN ACCORDANCE WITH AC43.13-1B, PAR 4-58, AND FIG. 4-6
USING THE FOLLOWING LEGEND:

-	EXISTING RIVET (REF)
+	MS2047DAD3
+	MS2047DAD4
⊕	MS2042BAD3
⊕	MS2042BAD4

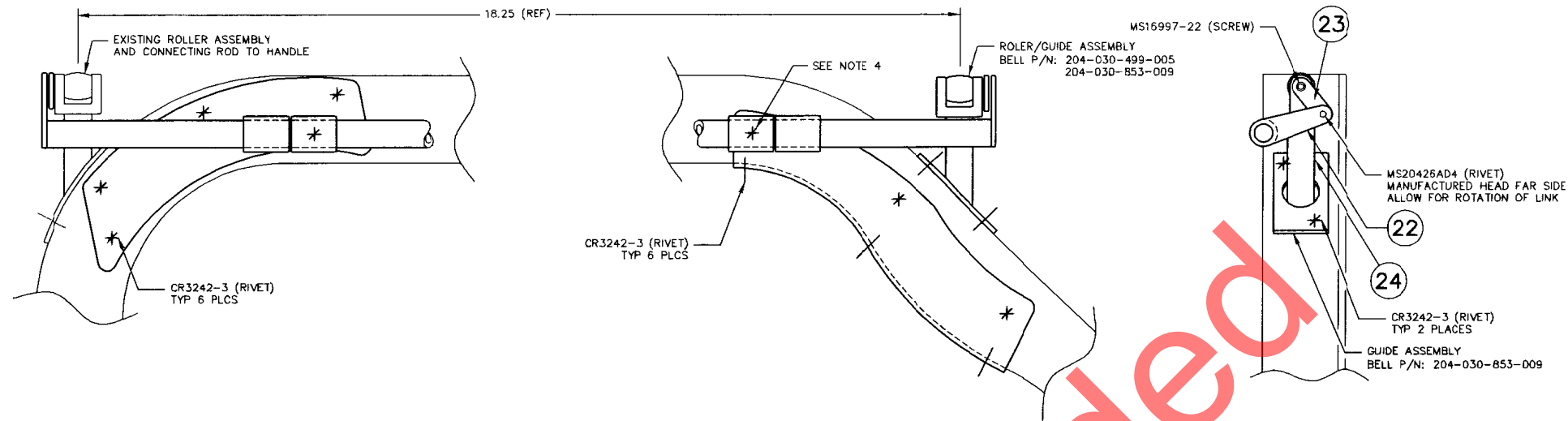
7. INSTRUMENTS FITTED INTO DOOR ARE EITHER REMOVED FROM LEFT HAND INSTRUMENT PANEL OR ARE PROVIDED AS EXTRA INSTRUMENTS. WIRING ROUTED THOUGH DOOR AND BEHIND LEFT SIDE INSTRUMENT PANEL AND PLUGGED INTO LEFT SIDE INSTRUMENT HARNESS. INSTRUMENT WIRING IN DOOR BUNDLED AND BOUND WITH CORD TO PROVIDE PIGTAIL WITH LENGTH TO ALLOW FULL OPENING OF DOOR.

	4	28	ARM GUIDE	EA20469-28	1	14	WINDOW RETAINER	EA20469-14
	1	27	DOOR PLATE	EA20469-27	1	13	INSTRUMENT WINDOW	EA20469-13
	1	26	DOOR PLATE	EA20469-26	1	12	FORWARD RIB	EA20469-12
	1	25	ARM	EA20469-25	1	11	ANGLE	EA20469-11
	1	24	ROD	EA20469-24	1	10	REARWARD RIB	EA20469-10
	2	23	LINK	EA20469-23	1	9	ANGLE	EA20469-09
	2	22	LUG	EA20469-22	1	8	PLACARD - INSTRUMENT PANEL	EA20469-08
1		21	DOOR COVER PANEL	EA20469-21	1	7	ANGLE	EA20469-07
		20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20	1	6	ALUMINUM STRIP	EA20469-06
		20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20	1	5	RUBBER STRIP	EA20469-05
		20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20	1	4	DOOR LATCH ASSEMBLY	EA20469-04
1		20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20	1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03
	1	19	EAGLE SERVICE INSTRUCTION	EA20469-19		2	INSTALLATION - DOOR MOUNTED INSTRUMENTS	
2	1	DASH NO.	DESCRIPTION	PART NO.	2	1	INSTALLATION - BUBBLE WINDOW	
QTY.			LIST OF MATERIALS (CONTINUED)		QTY.		LIST OF MATERIALS	PART NO.

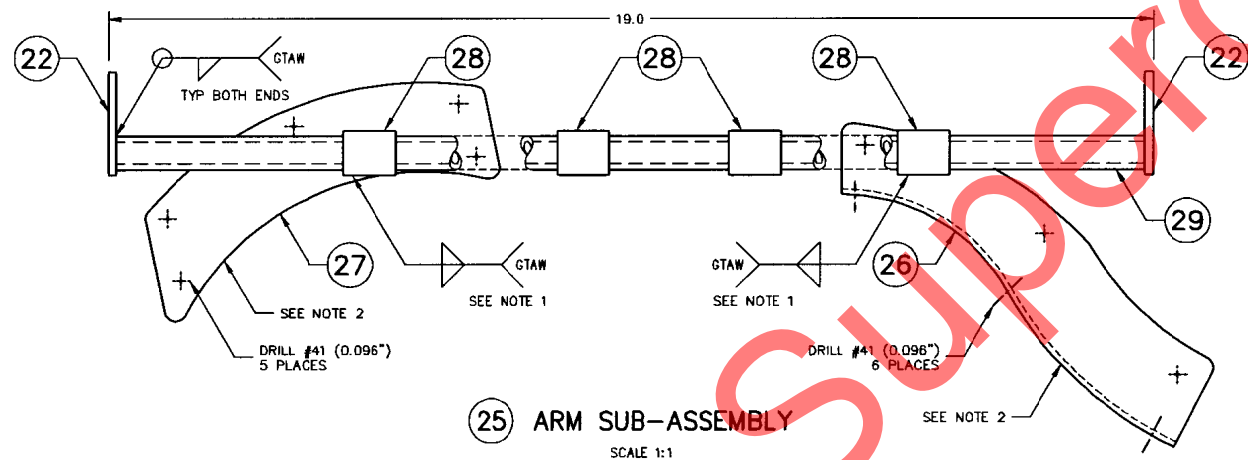
WEIGHT AND BALANCE						BASIC CODE		APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, 909 1045 McTAVISH ROAD N.E., CALGARY, AB. T2E 7G9			
ITEM	DESCRIPTION	WEIGHT (LBS.)	LONGITUDINAL ARM (INS.)	MOMENT (LB.-IN.)	LATERAL ARM (INS.)	MOMENT (LB.-IN.)	D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK	DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE	DRAWN: E. BURGOIN	28 SEPT 91	CHECKED:	EAGLE COPTERS LTD. 825 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION			
1 & 2	NET CHANGE WHEN VERTICAL SIGHTING DOOR REPLACES STANDARD DOOR.	2.0	+50.8	+101.6	-40.0	-80.0					STRESS:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			
	INSTRUMENT POSITION CHANGE (NET)			+45.0		-186.0						DECIMALS	ANGLES		
	NET CHANGE	2.0	73.3	+146.6	-133.0	-266.0						X.XXX ±0.010	±1/2°		
BASIC CODES:							* ∪	INSTALL NEW RIVET				X.XX ±0.03			
BJ = MS20470AD							+ ∓	REMOVE/REPLACE RIVET				X.X ±0.1			
BB = MS20426AD							- ∷	EXISTING RIVET							
LZ = NAS1097AD															
CX = MS2047000															

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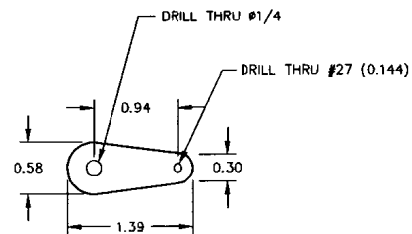
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 2000



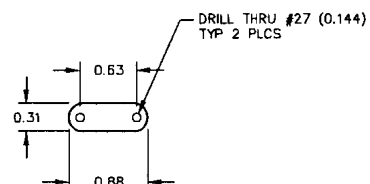
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



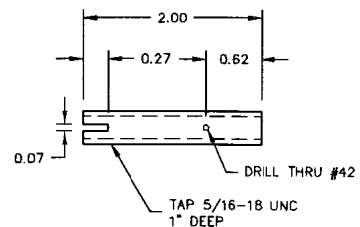
ARM SUB-ASSEMBLY
SCALE 1:1



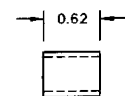
22 LUG
SCALE 1:1



23 LINK
SCALE 1:1



24 ROD
SCALE 1:1



28 ARM GUIDE
SCALE 1:1

- NOTES FOR SHEET 3.
- WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 6457A OR LATER REVISION.
 - HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PILOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 2D EDGE DISTANCE.
 - THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
 - OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

QTY.	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	29	ARM	EA20469-29	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
4	28	ARM GUIDE	EA20469-28	4130 STEEL	MIL-T-6736	#1/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	EA20469-27	MILD STEEL		0.063" SHEET
1	26	DOOR PLATE	EA20469-26	MILD STEEL		0.063" SHEET
1	25	ARM SUB-ASSEMBLY	EA20469-25			
1	24	ROD	EA20469-24	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
2	23	LINK	EA20469-23	4130 STEEL	MIL-S-18729	0.063" SHEET
2	22	LUG	EA20469-22	4130 STEEL	MIL-S-18729	0.063" SHEET
1	21	DOOR COVER PANEL	EA21469-21			
1	20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20			
1	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20			
1	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20			
1	20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20			
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19			
1	18	DOOR INNER SKIN	EA20469-18			
1	17	ANGLE	EA20469-17			
1	16	ARM REST ASSEMBLY	EA20469-16			
1	15	INSTRUMENT PANEL	EA20469-15			
1	14	WINDOW RETAINER	EA20469-14			
1	13	INSTRUMENT WINDOW	EA20469-13			
1	12	FORWARD RIB	EA20469-12			
1	11	ANGLE	EA20469-11			
1	10	REARWARD RIB	EA20469-10			
1	9	ANGLE	EA20469-09			
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08			
1	7	ANGLE	EA20469-07			
1	6	ALUMINUM STRIP	EA20469-06			
1	5	RUBBER STRIP	EA20469-05			
1	4	DOOR LATCH ASSEMBLY	EA20469-04			
1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03			
2	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
1	1	INSTALLATION - BUBBLE WINDOW				

BASIC CODE		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE	APPROVALS DRAWN: E. BURGON		DATE 26 AUG 1991		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DASH 8900 1045 McTAVISH ROAD N.E., CALGARY, AB, T2E 7G9				
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK		DASH NO. FOR LENGTH	CHECKED:				EAGLE COPTERS LTD. 823 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION				
BASIC CODES: BJ = MS20470AD BB = MS20426AD LZ = NAS1097AD CX = MS20470DD		* □ INSTALL NEW RIVET + ⬆ REMOVE/REPLACE RIVET - EXISTING RIVET	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		±1/2"		SCALE AS NOTED SHEET 3 OF 3		DWG. SIZE A1	DWG. NO. D2046901	REV. 1